

Date: Thursday, 7/19/2007 2:24:55 PM
User: Kim Johnston

Process Sheet

split

31

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI ACCESS STEP LH
Job Number	: 33650		
Estimate Number	: 11764		
P.O. Number	: <i>NA</i>	Part Number	: D206628022BL
This Issue	: 7/19/2007 S.O. No. : <i>NA</i>	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NA</i> Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 32392	Material	: <i>NA</i>
Written By	: <i>[Signature]</i>	Due Date	: 8/3/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	<i>1</i> Um: Each
Comment	: Est Rev'D as per ECN 766 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-022 CHG 002

rel - split w/o.

2.0	33650A	206L /407 STEP ASSY, RH
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Comment: Sub-Component SUB-COMPONENT

D2724-042 B *33650A**2/8/17 SB*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D27317	Mounting Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description

4 D2731-7 Mounting Lug

Batch

*B33136**B33752*

5.0	D2856400	Abrasion Strip
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Comment: Qty.: 1.1708 f(s)/Unit Total : 3.5123 f(s)

Pick :

Qty Part # Description

2 D2856-400 6.9" Abrasion Strip

Batch

*B332992**[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:24:55 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP LH

Job Number: 33650

Part Number: D206628022BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3394043

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3394-043 LUG ASS,Y

D337514x

7.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-12A Bolt

M104547-

8.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-13A Bolt

M104746-

9.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-15A Bolt

M104072-

10.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN960JD416 Washer

M104215-

11.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21042L4 Nut (or MS21042-4)

M102552-

EP 7/18/03 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:24:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP LH

Job Number: 33650

Part Number: D206628022BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Er 07/08/17 x (Kit)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-022

Location:

PPP Rev:

PPP 33650A 1/8/17 SP

1x

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.17

Job Completion



UL 07.08.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

628-022 Blue

Dart Aerospace Ltd.

Date: Thursday, 7/19/2007 2:25:01 PM
 User: Kim Johnston

Process Sheet

SPLIT 31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L /407 STEP ASSY, RH
 Job Number : 33650A
 Estimate Number : 11703
 P.O. Number :
 This Issue : 7/19/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D2724042
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2724 REVC
 Previous Run : 32392A Project Number : N/A
 Material : C
 Due Date : 8/3/2007 Qty: 3 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Qty Part # Description Batch:
 1 D2622-120C Extrusion 832858

Check Material for any Dents or Defects

a.m 07.07.23 3

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724
 Deburr and bevel ends for welding

a.m 07.07.23 3

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
 206 Step Endplate
 Pick:

Qty Part Number Description Batch
 2 D2734 End Cap 330883

SE 07-07-24 3

4.0 D34581 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 2 D3458-1 Plate 332480

SE 07-07-24 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:25:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 33650A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

332481

PE-07-07-24 3

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

A/R AL ROD Batch: M104121
M103794

Grind end cap welds flush

PE-07-07-24 3

PE 07-07-24 3

G.M. 07.07.25 3

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-07-25 (3)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Co 07/07/05 (x3RH)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

G.M. 07.07.25 3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PE-07-07-25 3

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

PE-07-07-25 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:25:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 33650A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description:

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig
DT
A/R AL ROD Batch: m103794

h.e. 07-07-25 3
h.e. 07-07-25 3
3

Grind end plate flush.

u.m

07.07.26

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-07-26 (3)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/26 (3 RH)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

HL

07-07-27

15.0

PG

PURCHASING



Comment: ISSUE P.O

4173
ATELIER DEBOSSELAGE
SPRAY PAINT DELFLEET BLUE
CLEAR DELFLEET

u 07.07.27 3

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RECEIVE AND INSPECT FOR TRANSIT DAMAGE

PC 7/2/2 (3)

17.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

En 07/08/09 (3 RH)

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

m104942
FD 07/08/12 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:25:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 33650A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 07/08/14 (7.324)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Rev # F CP 07/08/14 2/8/12 (1X)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.17

Job Completion



07.08.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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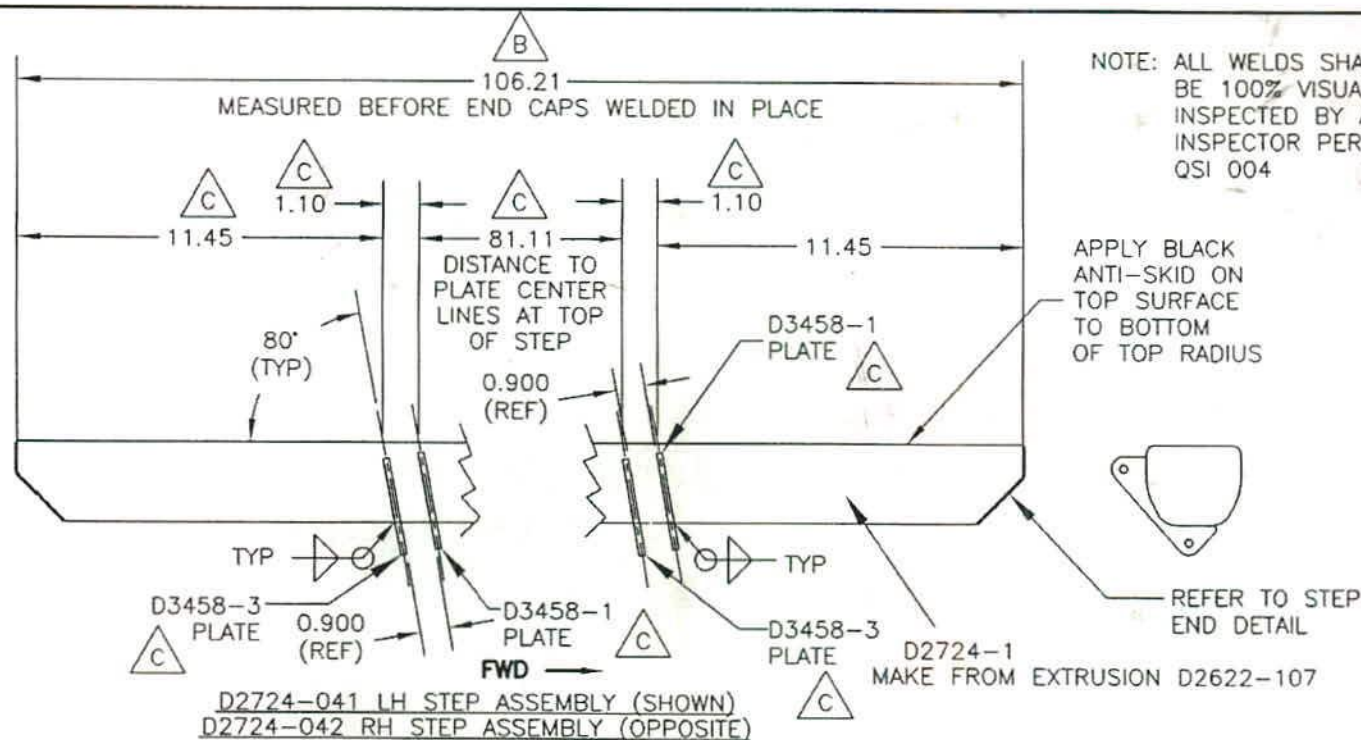
NOTE: Date & initial all entries

DART

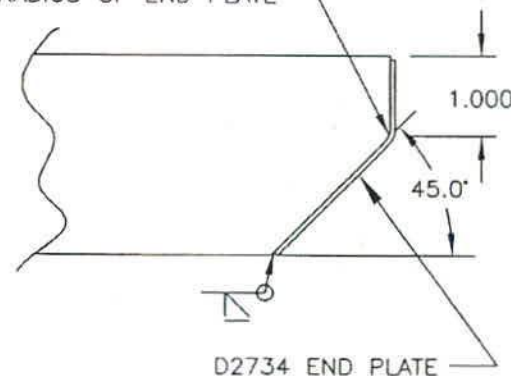
RELEASED

05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DESIGN KE
CHECKED
DRAWN BY PH
APPROVED
DRAWING NO. D2724
SHEET 1 OF 1

DATE

05.09.19

TITLE

206L/407 STEP ASSEMBLY

SCALE
NTS

A

97.12.04

NEW ISSUE

B

98.10.19

UPDATED WELD DETAIL
REVISED TOLERANCES

C

05.09.19

RE-DESIGN, ADD D3458-1/-3